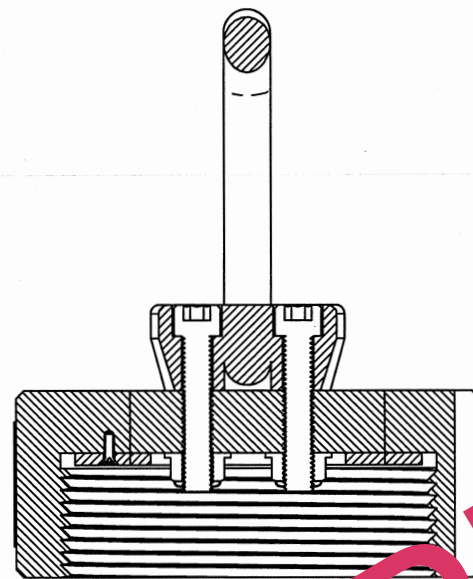
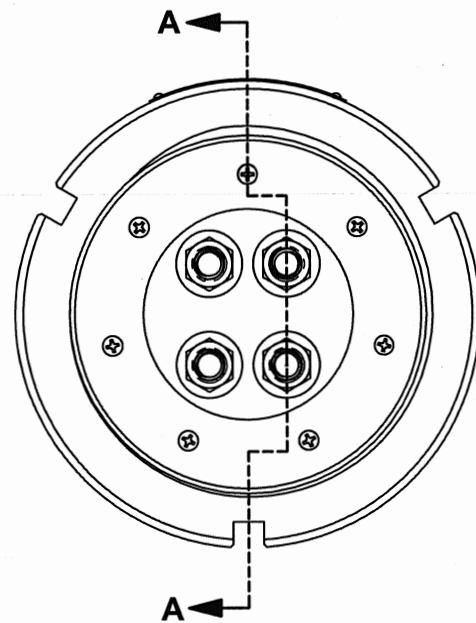


ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10302-041-1	RING
-2	1	RB 92700-10302-041-2	PAD
3	1	RB41011	DART PLACARD
4	1	McMaster#29505T240 OR EQUIV.	BLACK OXIDE STEEL HOIST RING 1/2"-13 X 12000 LBS. CAPACITY
5	4	McMaster#90044A164 OR EQUIV.	BLACK OXIDE STEEL SOCKET HEAD SCREW 1/2"-13 X 2-1/2" LG.
6	4	McMaster#90081A077 OR EQUIV.	ZINC PLATED STEEL SCREW NAIL #2 SIZE X 1/4" LG.
7	7	McMaster#90273A194 OR EQUIV.	ZINC PLATED STEEL FLAT HEAD SCREW #8-32 X 1/2" LG. X 82° CSK.
8	4	McMaster#92018A540 OR EQUIV.	GRADE G STEEL NYLON INSERT FLANGE LOCKNUT 1/2"-13 X 35/64" HEIGHT.



SECTION A-A  
(ROTATED 90° CW)

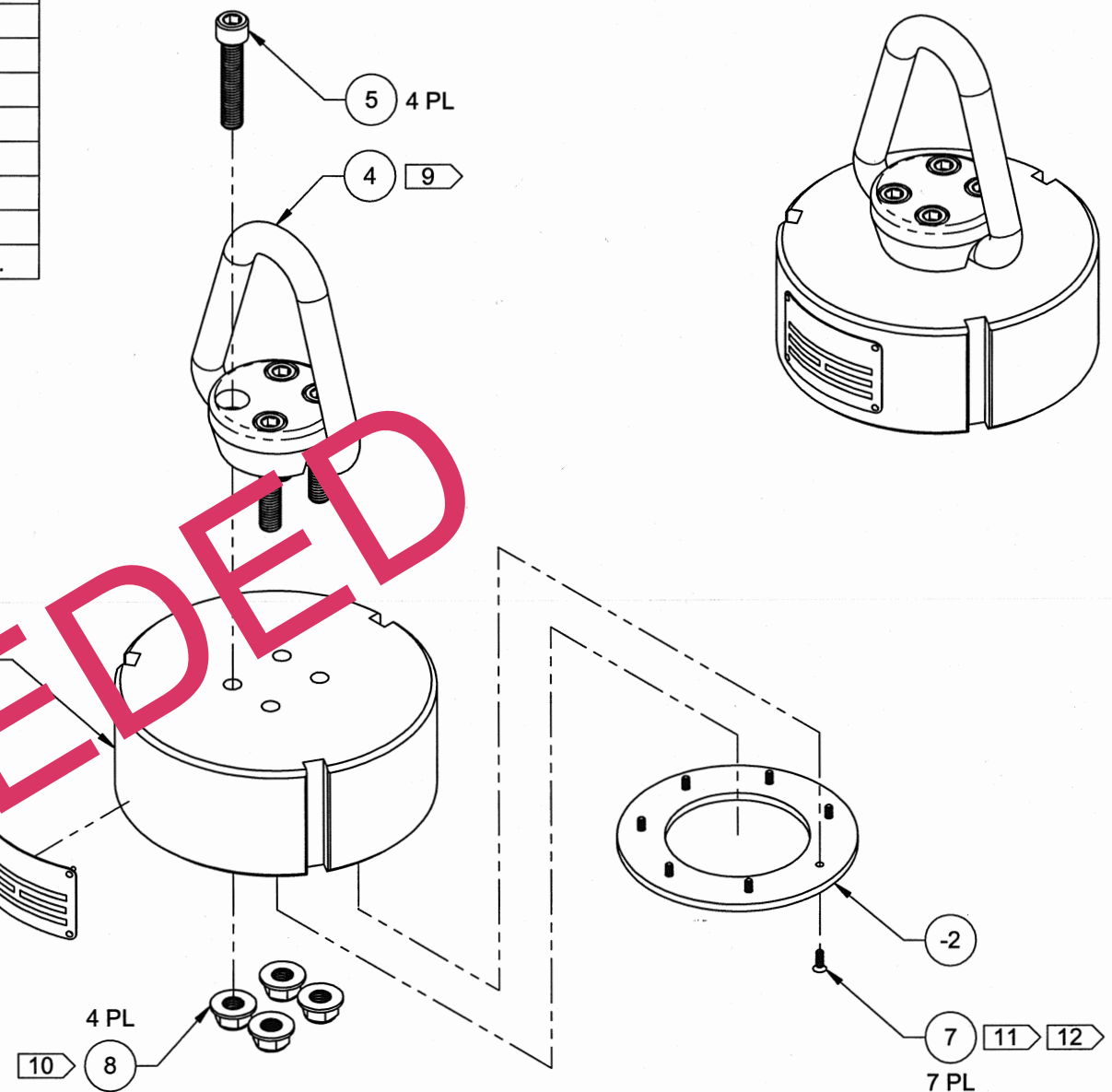
RB 92700-10302-041 LIFT RING ASSEMBLY

13

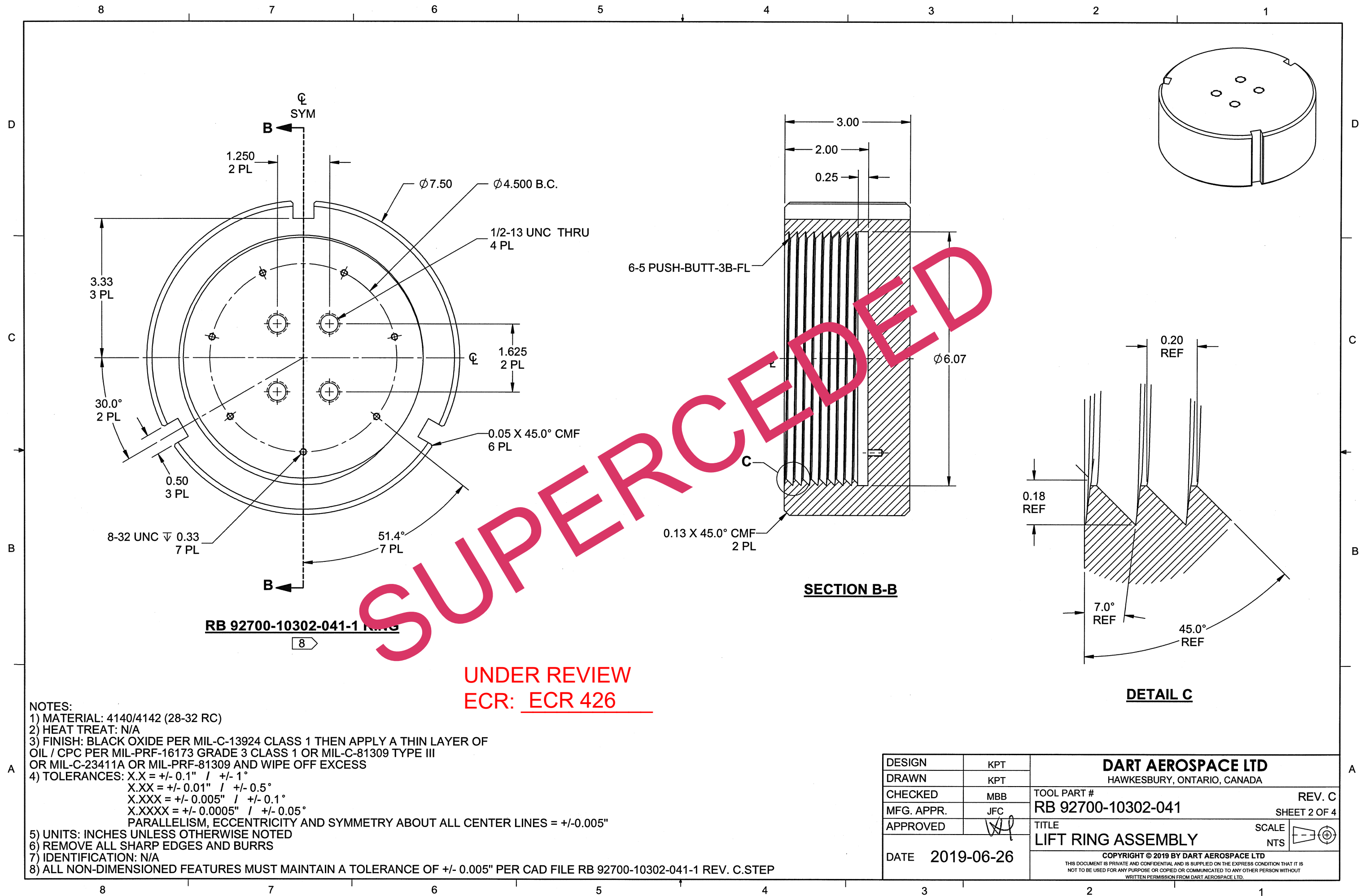
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: ENGRAVE THE TOOL P/N, S/N, AND "SAFE WORKING LOAD: 2300 LBS." ON THE DART PLACARD WHERE INDICATED
- 7) ASSEMBLE AS SHOWN
- 8) FORM ITEM 3 TO OUTER DIAMETER OF ITEM -1 BEFORE INSTALLATION
- 9) DISCARD SOCKET HEAD SCREWS (2-1/4" LG.) INCLUDED WITH ITEM 4, REPLACE WITH ITEM 5 (2-1/2" LG.)
- 10) TORQUE ITEM 8 TO 55-85 FT-LBS (660-1020 IN-LBS)
- 11) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 7 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS
- 12) INSTALL ITEM 7 HAND TIGHT
- 13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

UNDER REVIEW  
ECR: ECR 426



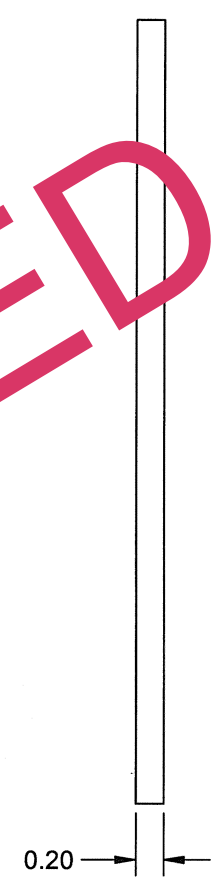
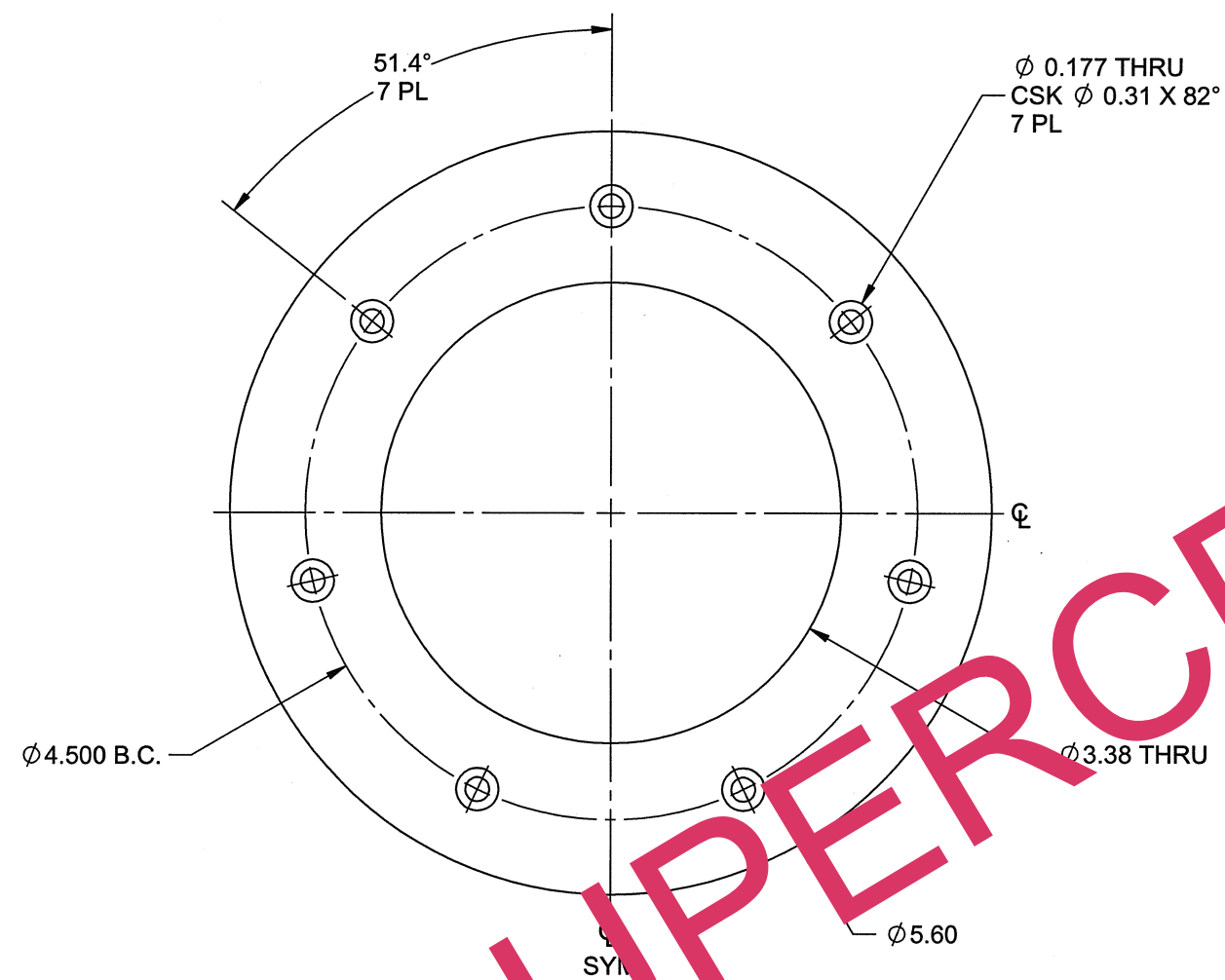
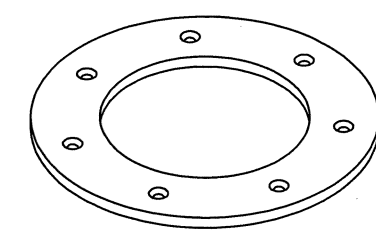
C	PRELIM FIT TEST DONE, RELEASED FOR PRODUCTION	19-781	KPT
B1	UPDATED DRAWING TEMPLATE CORRECTED NOTES ON SHEET 1 ADDED ITEMS 3 AND 6, AND LOAD TEST SHEET -1 ADDED 6-5 PUSH-BUTT-3B-FL THREAD CALLOUT. CORRECTED THREAD ORIENTATION. REMOVED THREAD Ø5.76 MINOR DIAMETER CALLOUT. REMOVED R0.008 MAX 6 PL DIM.		KPT
A	NEW ISSUE	18-631	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA TOOL PART # <b>RB 92700-10302-041</b> REV. C SHEET 1 OF 4 TITLE <b>LIFT RING ASSEMBLY</b> SCALE NTS COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	KPT		
CHECKED	MBB		
MFG. APPR.	JFC		
APPROVED			
DATE	2019-06-26		



8 7 6 5 4 3 2 1

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C  
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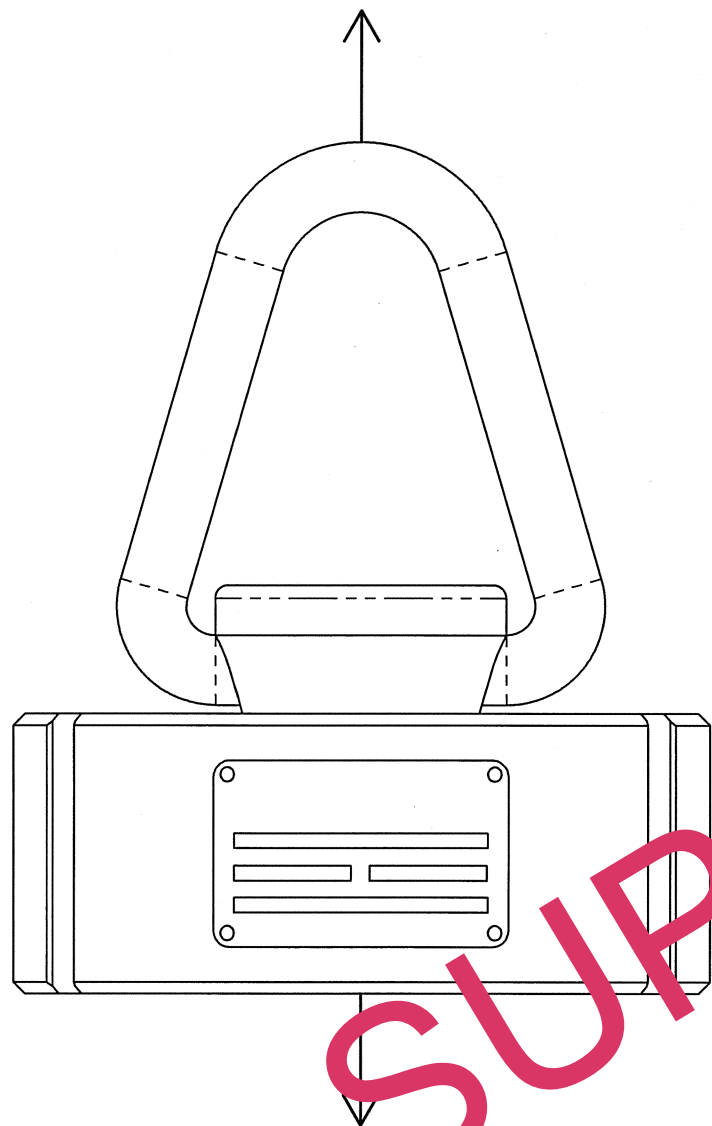
RB 92700-10302-041-2 PAD

UNDER REVIEW  
ECR: ECR 426

NOTES:  
1) MATERIAL: NYLON 6  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL SHARP EDGES AND BURRS  
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	JFC	RB 92700-10302-041	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DATE 2019-06-26		LIFT RING ASSEMBLY	NTS
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2090 KG / 4600 LBS

UNDER REVIEW  
ECR: ECR 426

#### FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE LIFT RING ASSEMBLY ON AN OVERHEAD LIFTING DEVICE. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT OF 2090 KG / 4600 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTE CONTINUALLY CHECKING FOR CRACKS, DEFLECTION AND DISTORTIONS
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, AND DISTORTIONS

INSPECTOR: \_\_\_\_\_

TESTER: \_\_\_\_\_

S/N: \_\_\_\_\_

DATE: \_\_\_\_\_

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	JFC	RB 92700-10302-041	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DATE 2019-06-26		LIFT RING ASSEMBLY	NTS
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